

5/22

2

DART AEROSPACE LTD	Work Order:	23196
Description: Fitting	Part Number:	D3257-1
Dwg: D3257 Rev. A	Qty:	10 11
Ref: 04.12.14 14		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	AL	05/05/09	10
2	MV	Cut blank: 0.500" x 0.500" x 1.180" long Bar Material: AISI 303 SS Bar (M303B0.500x0.500) Identify for D3257-1		05/05/09	10
3	MV	Machine as per Folio FA420 and Dwg D3257	JL	05/06/09	10
4	QC2	Inspect parts as they come off the CNC machine Identify as D3257-1	J.L.	05/06/05	11
5	MV	Deburr	JL	05/06/05	11
6	QC8	Second check	JL	05/06/05	11
7	ST	Identify and Stock	CL	05/06/08	11
8	AC	Cost / part <u>25.94</u>	R	05/06/07	11
9	DC	Close W/O <u>25.94</u> Inspect Level 21	HA	05/06/08	11

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	

RELEASED

04-05-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

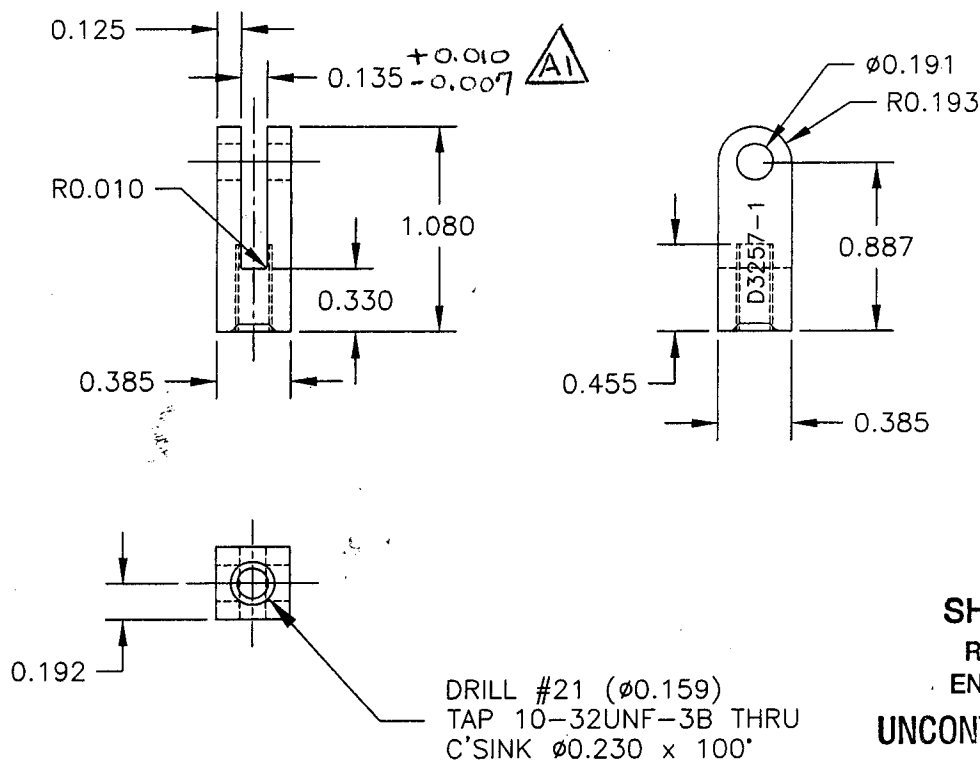
NCR: 23196		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/06/06	3	- chamfer of .230 is .016 to big on 2 pcs 0.240-245	JE 05.06.06	IT IS ACCEPTABLE FOR THIS TIME	JE 05.06.06 J.L 05/06/06	JE 05.06.07	JE 05.06.06	JE 05/06/07

Part No: D3257-1 PAR #: _____ Fault Category: Prod/machined parts NCR: Yes No DQA: JE Date: 05/06/08
 NOTE: Date & initial all entries QA: N/C Closed: JE Date: 05.06.08



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3257	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE FITTING	SCALE 1:1
A	04.01.27	NEW ISSUE	
AI	04.12.14	ADD TOLERANCE	

RELEASED
04.04.05 H



D3257-1 FITTING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK OF
NO. 23196

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: AISI 303 SS, BAR (REF DART SPEC. M303B0.500X0.500)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 06, 2005
09:55 am

Work Order No : 0023196
Project Name : D3257-1
Project For : WK522
Work Order Type : Main
Main WO Number :
House Part Number : D3257-1
Description : Fitting
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 05-05-05
Est Finish Date : 05-31-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : -0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00